

Work Order ID 55013



Page 1

January 5, 2010 12:46:00 PM

Item ID: D3572-041

Accept

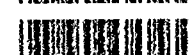


Setup Start



Revision ID:

Stop



Item Name: Guide Assembly

Start Date: 05/01/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 10-1-05 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3572

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

10.01.06

8

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

10.01.06

8

Small Fab

1-Cut Tube D3572-1 as per Dwg D3572
2-deburr both ends

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

27 5/10/01/06

8

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55013



January 5, 2010 12:46:00 PM

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide Assembly

Start Date: 05/01/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 111311
Large Fab

0.00

Memo

0.00

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572
2- grind weld flush at the end of tube only

10.01.08

8

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10.01.08

8

0

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

10.01.08

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January 5, 2010 12:46:00 PM



Page 3

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Stop



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Start Date: 05/01/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Chemical Conversion Coat per QSI005 4.1

0.00

BR

10-01-11

(8)



HandFinish

Memo

0.00

Hand Finishing

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

=> M

10-01-13

(x8)

Ø



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:45am
OVEN TEMPERATURE: 320°F
FINISH TIME: 9:15am

200

QC3- Inspect Part Finish

0.00

BR 10-01-13

(8)

Ø



QC

Memo

0.00

Quality Control

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Page 4

January 5, 2010 12:46:00 PM

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Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location 260

0.00



Packaging

Memo

0.00

Packaging

10-1-13

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/14

MF 10-1-14

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 12:46:04 PM

Page 1

Work Order ID: 55013

Parent Item: D3572-041

Parent Item Name: Guide Assembly


Comments: IPP Rev:F 09-04-28 As per Rev D JLM Verified By:DD

Start Date: 05/01/2010

Required Date: 15/01/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	em	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			110	f	224.1948	24.6316			
												
6061T6 RD TUBE 1.00 X .188W												

12 10.01.08

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	224.1947542	
109041	1.03	
112529	53.5647542	
113511	168	
18101	1.6	

8

D3572-3

 Guide

Manufactured No

130 Each 32.0000 40.0000

12 10.01.08

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST244	32	
52901	2	
54118	30	

8 2

D3572-5

 Bracket

Manufactured No

130 Each 39.0000 10.0000

12 10.01.08

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	39	
52657	4	
54119	35	

4

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

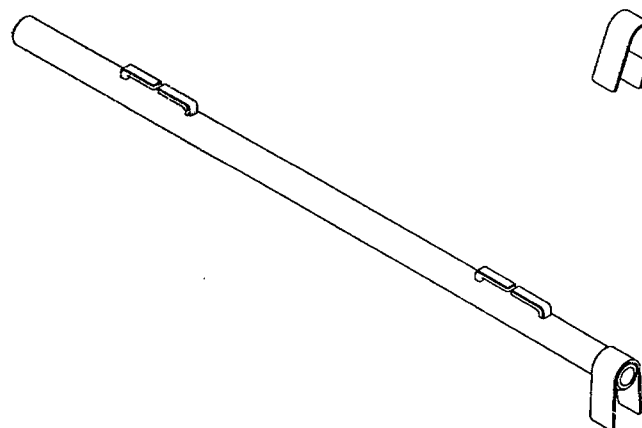
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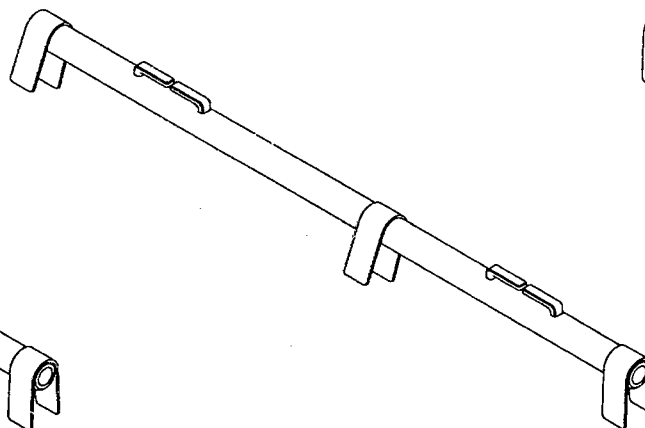
TEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-4	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55013

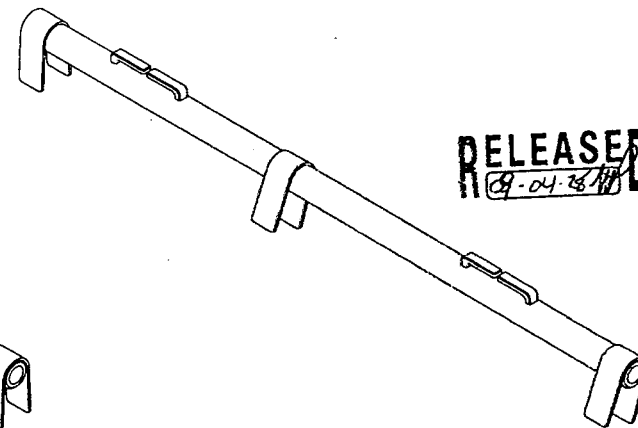
PR/10-1-05



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

RELEASED
09-04-18

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANOTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.05; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GUIDE ASSEMBLY	NTS
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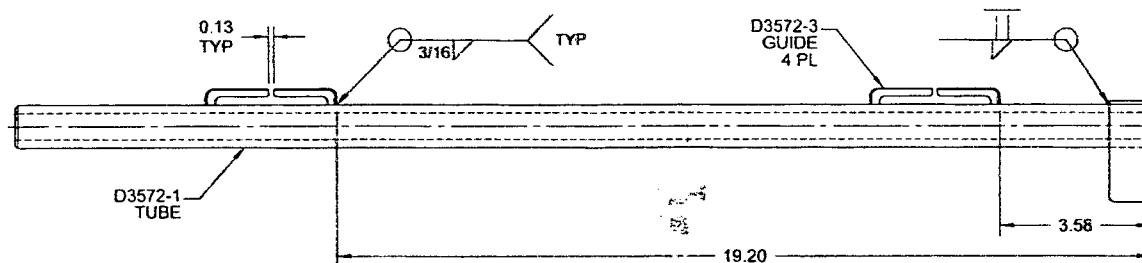
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

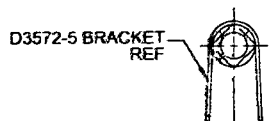
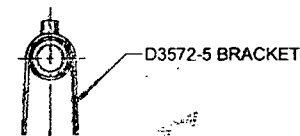
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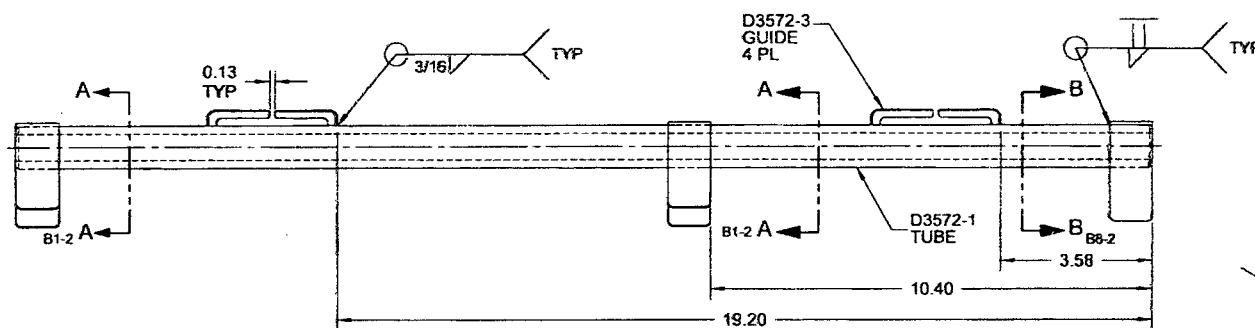
NOTE: Date & initial all entries



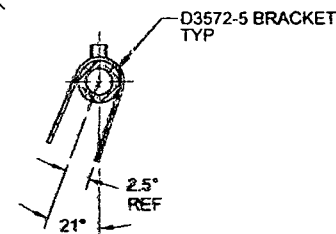
D3572-041 GUIDE ASSEMBLY



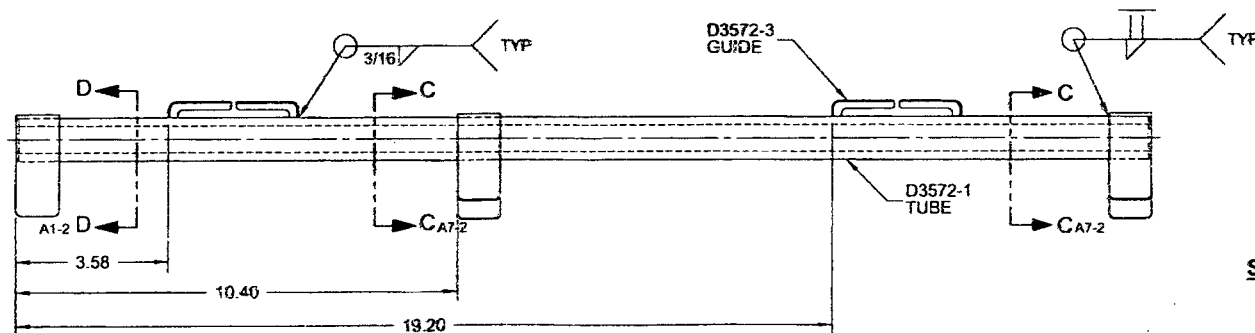
SECTION B-B C2-2



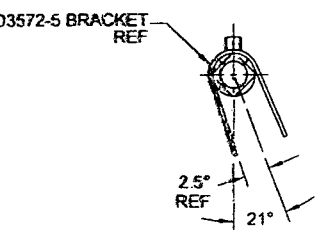
D3572-043 GUIDE ASSEMBLY



SECTION A-A C7-2 C4-2 (2 PL)

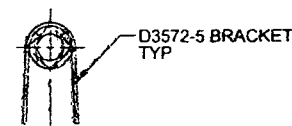


D3572-044 GUIDE ASSEMBLY



SECTION C-C A2-2 A5-2

RELEASED
09.04.17



SECTION D-D A7-2

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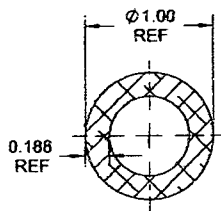
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

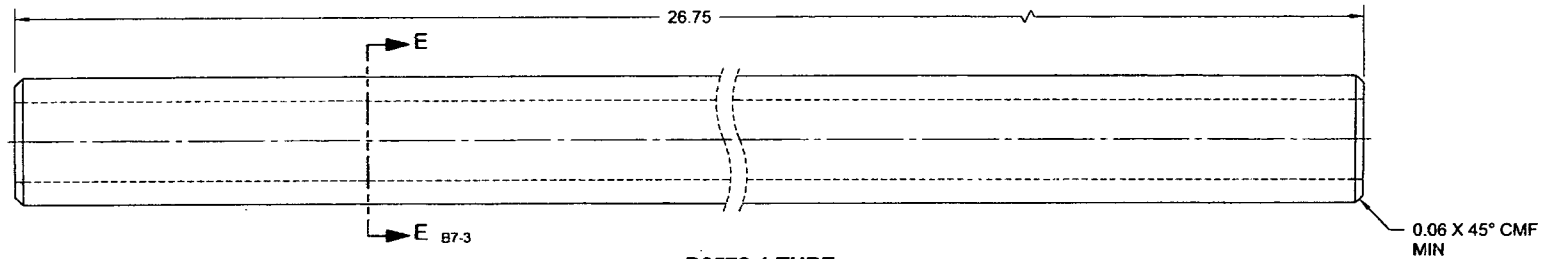
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NOTE: Date & initial all entries



SECTION E-E CS-3



D3572-1 TUBE

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

RELEASED
07/04/13

W/O 55013

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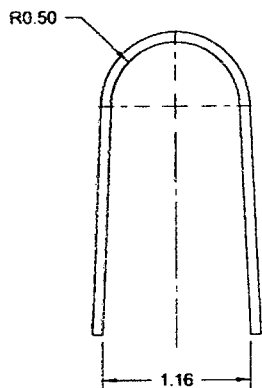
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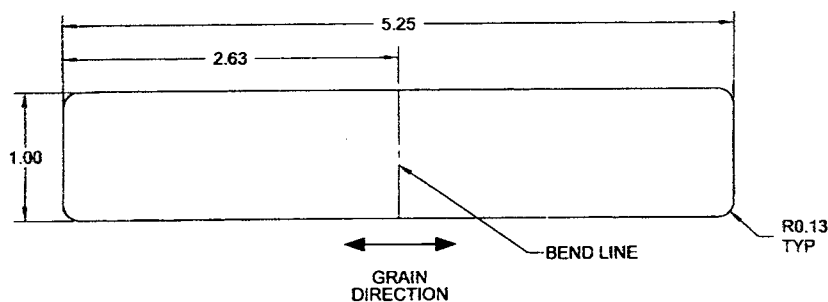
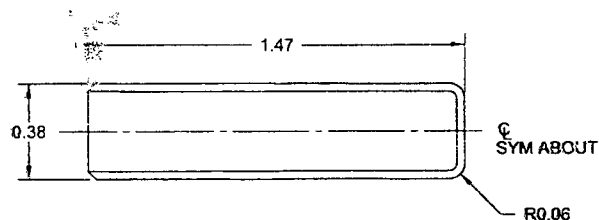
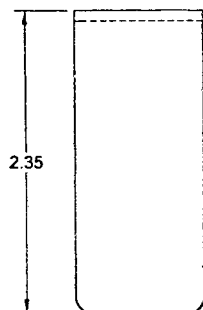
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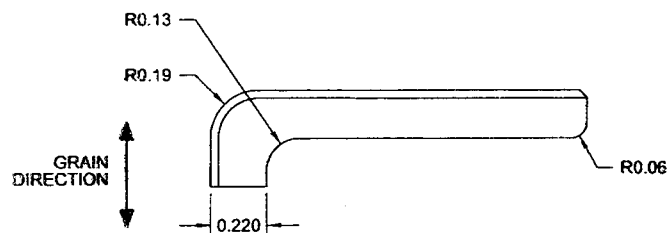
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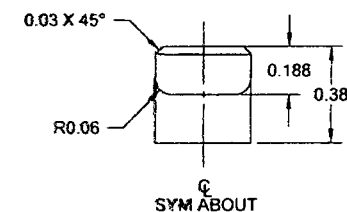
D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-5F FLAT PATTERN



D3572-3 GUIDE



D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

RELEASED
9/10/12

WU 55013

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED		DRAWING NO.	REV. D
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